

5/37

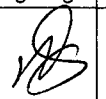
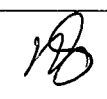
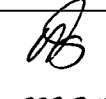
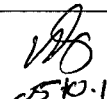
DART AEROSPACE LTD	Work Order:	24059
Description: Bearpaw Kit (19" x 16")	Part Number:	K10007
Dwg: D2435 Rev. E1; DSK086-3 Rev. A	Qty:	20
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: (1) K10007 Kit consists of Qty (2) D2435 Dwg not required	KJ	05.08.12	20
2	DC	Photocopy bluefile: K10007 D206-559 D500-572 D120-638 D058-678 and create labels per PPP K10007 CHG003 (Bag Bluefiles separately)	ML 35 KJ	05-09-13	20
3	GA	Cut 2 blanks per K10007 Kit Cut blank: 16.00" x 19.50" x 1.00" thick (+0.030/-0.000) per DSK086-3 Material: Black UHMW 1" (MUHMWB10) Batch: <u>11772L</u> <u>218612</u> MS SD	SD	05.09.29	20
4	MV	Inspect material for defects or damage prior to machining	SD MS/SD	05.09.29	20
5	MV	Machine as per Folio D2435 and Dwg D2435 Identify as D2435	EP MS/SD	05.09.29	20 P10
6	QC2	Inspect parts as they come of the CNC machine	EP/SD	05.09.29	20
7	MV	Deburr	EP MS/SD	05.09.29	20
8	QC8 & 5	Second inspection	SD	05.10.11	20
9	KP	Pick: Packing Kit (Note: D2435 is not on the BOM, but is in as material from step 3) Qty Part Number Description Batch 4 D2182B050 Rubber Cushion B23172 8 D2274 Radius Block B23372 2 D2435 Bearpaw B24059 4 D2438 Clamp B23175 8 D2529 Washer B23177 8 AN4-15A Bolt M17566 8 AN4-17A Bolt M15432 16 AN960JD416 Washer M17566 8 MS21042L4 Nut (or -4) M15924 2 QS200M44S Clamp (29) M16020/M18332 1 Paperwork package from Step 2	DL	05/10/12	20
10	QC4	Inspect Kit for 100% Completeness on the W/O	CL	05/10/12	20
11	PK	Identify and pack for shipping as per PPP K10007 REV. E	CL	05/10/12	20
12	AC	Cost / part <u>178.74</u>	SHC	05.10.13	20
13	DC	Close W/O <u>168.02</u> Inspect Level 21	CL	05/10/13	20


Rev	Date	Change	Revised By	Approved
A	99.12.17	K10007 created for Bear paw kit (MPP 2000)	EC	
B	01.03.21	Added OH-58 paperwork (MPP 2092)	EC	
C	01.11.08	Revised Step 3 and Added Level 21	SM	
D	03.03.26	Reformat; Incorporated D2435	KJ/RF	
E	04.02.17	Blank size changed, tolerance added to Step 3	KJ/JLM	

2070000536
ASRELEASED
04.02.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-11	5	-origin on Haas 1. moved .240" on Y axis	 05-10-11	clean sensors on H.A.B Scrap & replace	SD 05-10-08	 05-10-11	 05-10-11	 05-10-11

Part No: _____ PAR #: _____ Fault Category: _____

NCR: Yes ☒ No ☐ DQA:  Date: 05/10/13

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	24059
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435	Rev: E1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.065 x 45°	/			
B	5.500	+/-0.030	5.505	/			
C	0.200	+/-0.030	.208	/			
D	R0.250	+/-0.030	R.250	/			
E	0.250	+/-0.010	.245	/			
F	0.625	+/-0.030	.627	/			
G	0.25 x 45°	+/-0.030	.232 x 45°	/			
H	0.375	+/-0.010	.367	/			
I	19.000	+/-0.030	19.00	/		Tape	
J	0.950	+0.030/-0.010	.955	/			
K	Ø0.260	+0.005/-0.000	Ø.261	/			
L	Ø0.930	+/-0.030	Ø.930	/			
M	0.30	+0.030/-0.000	.302	/			
N	0.375	+/-0.030	.382	/			
O	7.375	+/-0.030	7.375	/			
P	4.250	+/-0.010	4.250	/			
Q	2.000	+/-0.030	2.000	/			
R	9.000	+/-0.010	9.000	/			
S	15.750	+/-0.030	15.750	/			

Measured by: SA	Audited by: BG	Prototype Approval:	N/A
Date: 08.09.29	Date: 08.09.29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	#

RELEASED

04.01.15

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 11, 2005
01:37 pm

Work Order No : 0024059

Project Name : K10007

Project For : WK537

Work Order Type : Main

Main WO Number :

House Part Number : *K10007

Description : Bearpaw Kit 19" x 16"

Manufactured : Yes

Amount Req'd : 20

Amount Done : 0

Start Date : 08-11-05

Est Finish Date : 09-11-05

Act Finish Date :

Drawings Req'd : No

Ok for Approval :

Approval Rec'd :

Department Code:

Burden Flags : NNNNNNNN

WO Status : Open

Invoice State : Not Invoiced

Invoice Date :

Invoice Number :

Invoice Amount : 0.00

Order Entry No :

OE Value : 0.00

Est Mark Up : 0.000%

Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00